

Work Order ID 62585 - 2

Monday, October 04, 2010 3:20:41 PM

Page 1

Item ID: D206-628-021BL

Revision ID:

Item Name: Heli-Access-Step LH, Blue

Start Date: 10/5/2010 Start Qty: 4.00

Required Date: 10/22/2010 Req'd Qty: 4.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: umf

Date: 10-10-04 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-628

F

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

CHG 003

Pro →  
OK for BG 10/10/19  
8/10/11/19

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10/11/19 SP 40

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/10/11/19

(+2  
24)

**Work Order ID 62585**

Monday, October 04, 2010 3:20:41 PM



Page 2

Item ID: D206-628-021BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH, Blue

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-628-021

Location: 119

PPP Rev: 5

10/11/09  
10/11/09  
22  
29

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

ch 10/11/09  
mf  
10-11-9

# Picklist Print

Monday, October 04, 2010 3:20:40 PM

Page 1  
3

Work Order ID: 62585

Parent Item: D206-628-021BL

Parent Item Name: Heli-Access-Step LH, Blue



Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevF: add AN960JD416 DD 09.11.17 verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A  Bolt		Purchased	No				Each	168.0000	4	16			

Location	Loc Qty	Loc Code
ST357	152	
114752	1	
115371	150	
115422	1	
ST358	16	
113359	16	

AN4-15A  
  
Bolt

Purchased No

Each 577.0000 8

Location	Loc Qty	Loc Code
ST338	112	
ST358	465	
107737	12	
108868	60	
109148	4	
111295	52	
112905	12	
114232	3	
114292	32	
114615	56	
114784	58	
115108	76	
115371	100	

16

16

32

7X

25X

# Picklist Print

Monday, October 04, 2010 3:20:40 PM

Page 2

Work Order ID: 62585

Parent Item: D206-628-021BL

Parent Item Name: Heli-Access-Step LH, Blue



Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased No



Washer

Each 24.0000 12 48



*measured 10/10/10*

## Location

## Loc Qty

## Loc Code

ST300

24

113288

24

Each

0.0000

1

4

D2724-041

Manufactured No



206L Step Assembly

D2731-7

Manufactured No



Mounting Lug

Each

55.0000

4

16

## Location

## Loc Qty

## Loc Code

ST420

16

60996

16

ST470

39

59202

15

61653

24

Each

0.0000

8

32

D2732-030

Manufactured No



Rubber Cushion

D3394-043

Manufactured No



Lug Assembly

Each

31.0000

4

16

## Location

## Loc Qty

## Loc Code

ST420

19

60997

19

ST475

12

52331

12

*12*

*32*

*B56516*

*10/10/10*

*B62589*

*15*

Monday, October 04, 2010 3:20:40 PM

Shop Packet Print

Page 2

# Picklist Print

Monday, October 04, 2010 3:20:40 PM

Page 3

Work Order ID: 62585

Parent Item: D206-628-021BL

Parent Item Name: Heli-Access-Step LH, Blue



Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

Each

4,434.000

12

48



Nut



10/10/19 SF (40)

## Location

## Loc Qty

## Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

40

Monday, October 04, 2010 3:20:40 PM

Shop Packet Print

Page 3

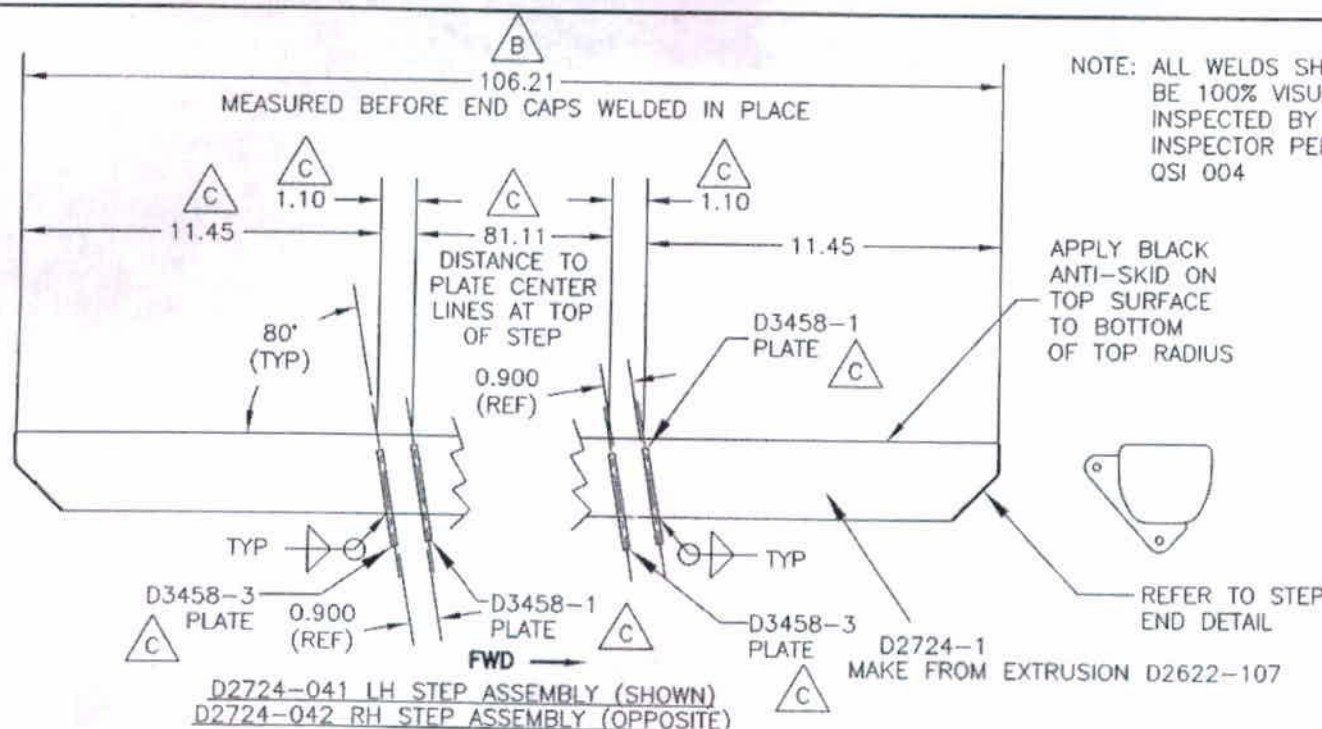
# 5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

**REFERENCE ONLY**  
**DART**

RELEASED  
05.11.14

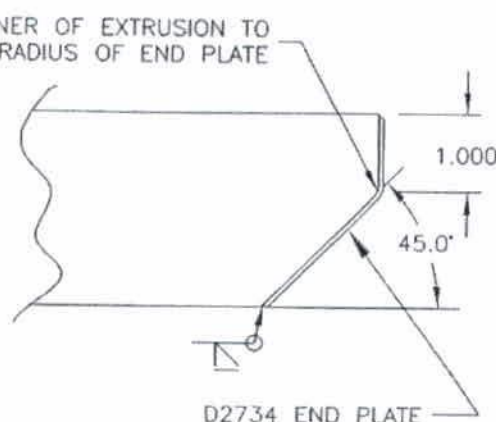


#### D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

#### D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		NEW ISSUE
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
				206L/407 STEP ASSEMBLY
				SCALE NTS
				SHEET 1 OF 1
				REV. C

## Change Record

Part Number D206-628-021/-022  
Description HELL ACCESS-STEP installation (206L)

Page 1 of 1[illegible]